

Work Order ID 100599-2

April-24-13 9:48:46 AM

\*100599\*

RUSH

Page 1

Item ID: D4543-4

Revision ID:

Item Name: Retainer, Outer, R11

Start Date: 4/24/13

Start Qty: 30.00

\*30\*

Required Date: 5/08/13

Req'd Qty: 30.00

\*30\*

Reference:

Approvals:

Process Plan: MLS

Date: 13-04-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4543

B

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut D4543-3F as per dwg

6061 T6 .032

Prog rev: B

Dwg rev: B

2- Deburr

38

0

Jm13-4-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

38

0

Jm13-4-24





Work Order ID 100599

\*100599\*

Page 3

April-24-13 9:48:46 AM

Item ID: D4543-4

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Retainer, Outer, RII

Start Date: 4/24/13 Start Qty: 30.00

\*30\*

Cust Item ID:

Required Date: 5/08/13 Req'd Qty: 30.00

\*30\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

Hand Finishing

38 76 13-429

160

QC7-Inspect Chemical Conversion Coat

0.00

\*160\*

QC

Memo

0.00

Quality Control

Das  
221  
13430

38  
can

170

Identify as per dwg & Stock Location:

0.00

\*170\*

Packaging

Memo

0.00

Packaging

SNIP

43480 8

Work Order ID 100599

\*100599\*

Page 4

April-24-13 9:48:46 AM

Item ID: D4543-4

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Retainer, Outer, RH

Start Date: 4/24/13

Start Qty: 30.00

\*30\*

Cust Item ID:

Required Date: 5/08/13

Req'd Qty: 30.00

\*30\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

\*180\*

QC

Memo

0.00

Quality Control

13/5/6

mk

13-4-30



# Picklist Print

April-24-13 9:48:50 AM

Page 1

Work Order ID: 100599

\*100599\*

Parent Item: D4543-4

\*D4543-4\*

Parent Item Name: Retainer, Outer, RH

Start Date: 4/24/13

Required Date: 5/08/13

Start Qty: 30.00

Required Qty: 30.00

## Comments:

IPP revA 12.01.12 New Issue EC verified by:DD  
REV:B 12.02.24 as per dwg revA DD verf:EC  
13.04.23 as per dwg revB DD verf:JLM

IPP  
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032

Purchased

No

100

sf

1,183.770

1.144

36.12632

**\*M6061T6S 032\***

\*\*

32

JmB-4-24

6061-T6 Sheet 0.032"

## Location

## Loc Qty

## Loc Code

MAT021

1183.77

121099

171.94

122256

46.78

122737

44.8

123097

71.9

123135

37.7

123137

51.85

123293

58.5

123483

260.6

123701

47.85

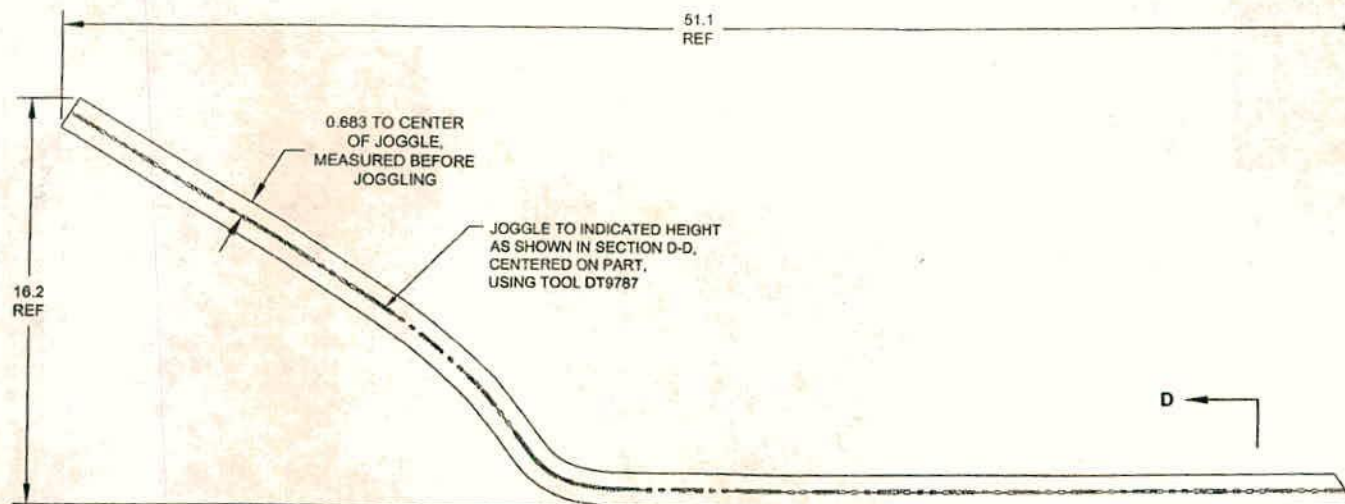
124629

199.85

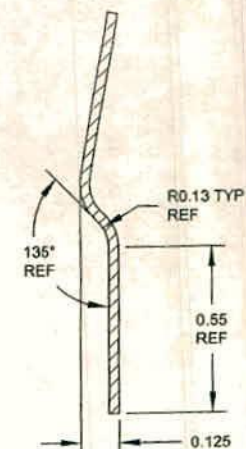
125341

192

125341



100539 MJS  
13-01-24



SECTION D-D  
JOGGLE DETAIL  
SCALE 12X

**D4543-4 RETAINER, RH OUTER**  
(SIDE/TOP) B

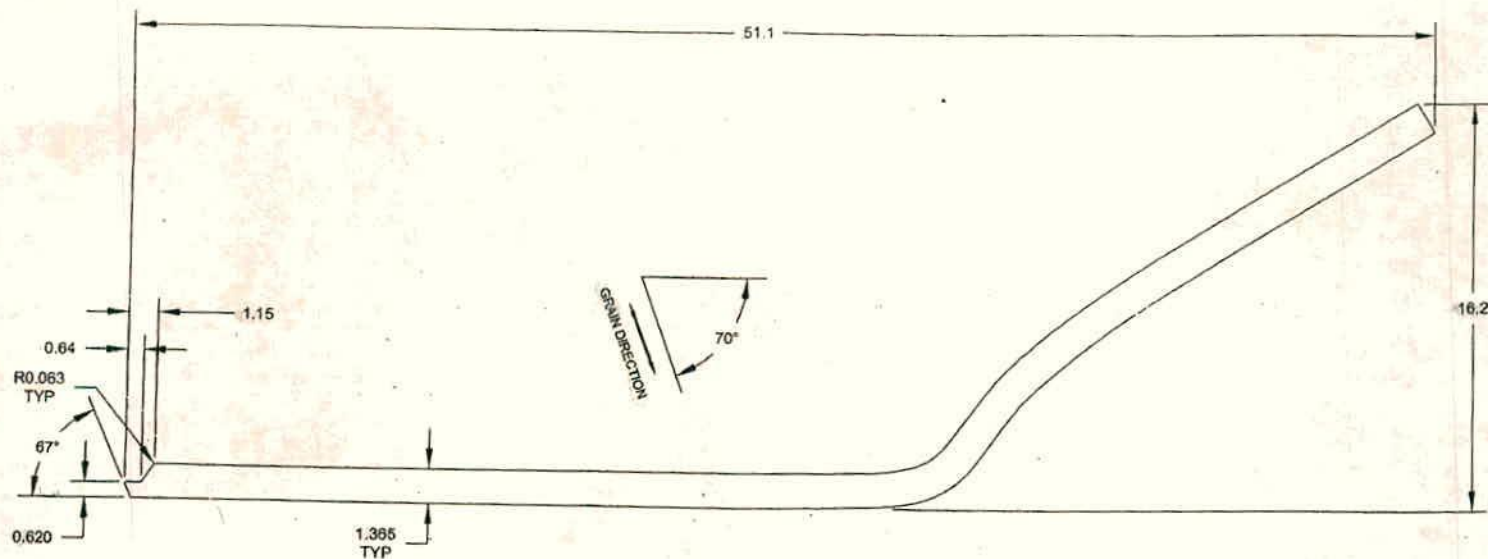
**RELEASE**  
2013-04-22

**NOTES:**

- 1) MATERIAL: MAKE FROM D4543-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.24 lbs

DESIGN	<i>P</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>P</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MS</i>	D4543	SHEET 5 OF 9
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	RETAINER, OUTER	NTS
DATE	13.04.15	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. USE IS LIMITED TO THE OFFICIAL CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





**D4543-3F FLAT PATTERN**



**RELEASED**  
2013-04-22

**NOTES:**

- 1) MATERIAL: 0061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) PROFILE PER DRAWING FILE "D4543-3F-REVB.DXF"

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4543	SHEET 6 OF 9
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